

Work Order ID 83740

83740

Page 1

April-24-12 1:27:26 PM

Item ID: D412-630-034

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Heli Access Step RH Folding

Stop ***NS2***

Start Date: 24/04/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 08/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/04/24*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-630	Rev M								
100		0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile & create labels per PPP D412-630-034 CHG003								
110		0.00							
110	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg D412-630 p.14								
	Coat all hardware with LPS3 rust inhibitor								
	A/R LPS3 batch: <i>M119317</i>								
	COAT exposed HARDWARE WITH LPS PROCYON								
	A/R LPS PROCYON BATCH: <i>M114596</i>								

12-5-1

12/04/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 08/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

130

Pick Kit

0.00

130

Packaging

Memo

0.00

Packaging

140

QC4- 100% Inspect kits for completeness

0.00

140

QC

Memo

0.00

Quality Control

Scalene

*74
PH*

11X

*SP
12-05-02*

Scalene

*74
PH*

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Packaging	0.00							
150									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-630-034								
	Location:								
	PPP Rev: <u>A</u>								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

AK

Sp
12-05-02

12/5/11

MF

12-05-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 83740

83740

Parent Item: D412-630-034

D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 24/04/2012

Required Date: 08/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-11-08 JLM
IPP rev B ecn1019, added D2807-041 EC verified by:DD
IPP rev :C 11.01.06 added route seq ID DD vef:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310C8 *AN310C8* Nut		Purchased	No			110	Each	44.0000	2	8			
									**				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST344		24							
				118378		2							
				120644		2							
				120769		20							
				ST347		20							
				121068		20							
AN3C21A *AN3C21A* BOLT		Purchased	No			110	Each	58.0000	2	8			
									**				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST352		58							
				109148		2							
				119798		36							
				120781		20							
AN8C16 *AN8C16* Bolt		Purchased	No			110	Each	36.0000	2	8			
									**				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST343		36							
				106066		2							
				120578		14							
				120832		20							

EB 12/04/26

EB 12/04/26

EB 12/04/26

EB 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

Work Order ID: 83740

83740

Parent Item: D412-630-034

D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 24/04/2012

Required Date: 08/05/2012

Start Qty: 4.00

Required Qty: 4.00

(D2813 Manufactured No
D2813
Washer

110 Each 22.0000 2 8

**

Location

Loc Qty

Loc Code

ST018

22

69386

1

79691

1

80848

20

(D3395-1 Manufactured No
D3395-1
Bushing

110 Each 27.0000 4 16

**

Location

Loc Qty

Loc Code

ST041

27

71563

8

81118

19

(D3562-042 Manufactured No
D3562-042
Step Assembly, RH

110 Each 0.0000 1 4

B81122 (4) **

(MS21043-3 Purchased No
MS21043-3
Nut

110 Each 1,171.000 4 16

**

Location

Loc Qty

Loc Code

FG

72

103691

72

GA

140

120693

140

ST301

959

118077

2

118614

83

118686

30

119758

20

121255

824

April-24-12 1:27:31 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Page 4

Work Order ID: 83740

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

83740

D412-630-034

Start Date: 24/04/2012

Required Date: 08/05/2012

Start Qty: 4.00

Required Qty: 4.00

MS24665-302

Purchased

No

110

Each

198.0000

2

8

MS24665-302

Cotter Pin

**

Location

Loc Qty

Loc Code

ST309

198

120521

198

MS24693-C280

Purchased

No

110

Each

48.0000

2

8

MS24693-C280

Screw

**

Location

Loc Qty

Loc Code

ST289

25

120498

25

ST310

23

121060

23

NAS1515H3

Purchased

No

110

Each

214.0000

6

24

NAS1515H3

Washer

**

Location

Loc Qty

Loc Code

ST277

214

118078

6

119438

4

120142

11

120518

26

120770

67

121415

100

Handwritten notes and signatures:
 12/04/26
 7117460 (8x)
 12/04/26
 8
 24
 12/04/26
 24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 5

Work Order ID: 83740

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

83740

D412-630-034

Start Date: 24/04/2012

Required Date: 08/05/2012

Start Qty: 4.00

Required Qty: 4.00

C NAS1515H5L Purchased No

*NAS1515H5I *

WASHER

110 Each 98.0000 4 16

**

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

58

119902

3

121068

25

121444

30

C NAS1515H8 Purchased No

NAS1515H8

Washer

110 Each 89.0000 4 16

**

Location

Loc Qty

Loc Code

ST277

89

111275

4

111411

35

121068

50

0 AN44C7A Purchased No

AN44C7A

Eyebolt

130 Each 27.0000 4

**

Location

Loc Qty

Loc Code

ST362

27

111308

17

120872

10

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Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 83740

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

83740

D412-630-034

Start Date: 24/04/2012

Required Date: 08/05/2012

Start Qty: 4.00

Required Qty: 4.00

AN4C10A

Purchased

No

130

Each

51.0000

** 0 4

AN4C10A

Bolt

Location

Loc Qty

Loc Code

ST356

51

114523

30

120820

11

120840

10

AN4C15A

Purchased

No

130

Each

229.0000

** 2 8

AN4C15A

Bolt

Location

Loc Qty

Loc Code

ST358

229

115835

2

118706

27

120360

200

AN4C6A

Purchased

No

130

Each

175.0000

** 0 4

AN4C6A

Bolt

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

171

116704

2

120423

169

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

April-24-12 1:27:31 PM

Page 7

Work Order ID: 83740

83740

Parent Item: D412-630-034

D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 24/04/2012

Required Date: 08/05/2012

Start Qty: 4.00

Required Qty: 4.00

AN5C15A

Purchased

No

130

Each

77.0000

2 8

**

SP

h

AN5C15A

Bolt

Location

Loc Qty

Loc Code

ST338

77

118191

3

120422

30

120833

19

121162

25

8x

D2806-1

Manufactured

No

130

Each

37.0000

2 8

**

SP

h

D2806-1

Bushing

Location

Loc Qty

Loc Code

ST018

37

79527

13

82033

24

8x

D2806-3

Manufactured

No

130

Each

26.0000

2 8

**

SP

h

D2806-3

Bushing

Location

Loc Qty

Loc Code

ST018

26

79528

2

82034

24

2x

6x

D2810-5

Manufactured

No

130

Each

16.0000

1 4

**

SP 12-05-02 h

D2810-5

Strut

Location

Loc Qty

Loc Code

ST265

16

52034

1

79690

1

81072

8

82256

6

4x

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Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 8

Work Order ID: 83740

83740

Parent Item: D412-630-034

D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 24/04/2012

Required Date: 08/05/2012

Start Qty: 4.00

Required Qty: 4.00

D3396-1 Manufactured No

130 Each 42.0000

2 8
**

D3396-1

Spacer

Location

Loc Qty

Loc Code

ST041

42

78885

2

82036

40

MS21043-4

Purchased No

130 Each 1,452.000

4 16
**

MS21043-4

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1412

119546

213

120308

199

121162

1000

MS21043-5

Purchased No

130 Each 638.0000

3 12
**

MS21043-5

Nut

Location

Loc Qty

Loc Code

FG

20

101418

20

ST300

4

112314

4

ST301

614

116548

100

118159

89

119307

25

119537

200

121283

200

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Page 8

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

83740

D412-630-034

Start Date: 24/04/2012

Required Date: 08/05/2012

Start Qty: 4.00

Required Qty: 4.00

NAS1515H4

Purchased

No

130

Each

174.0000

7

28

**

NAS1515H4

Washer

Location

Loc Qty

Loc Code

ST277

174

116169

3

117460

1

117735

3

118078

48

118612

9

120120

50

120770

50

121060

10

23x

25x

NAS1515H5

Purchased

No

130

Each

193.0000

7

28

**

NAS1515H5

Washer

Location

Loc Qty

Loc Code

FG

25

103286

5

103691

20

GA

100

120449

100

ST277

68

120299

15

120304

53

28x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

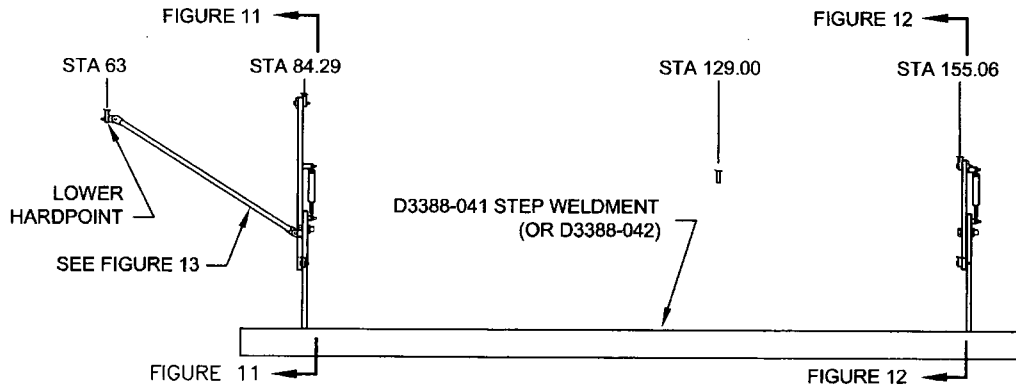
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

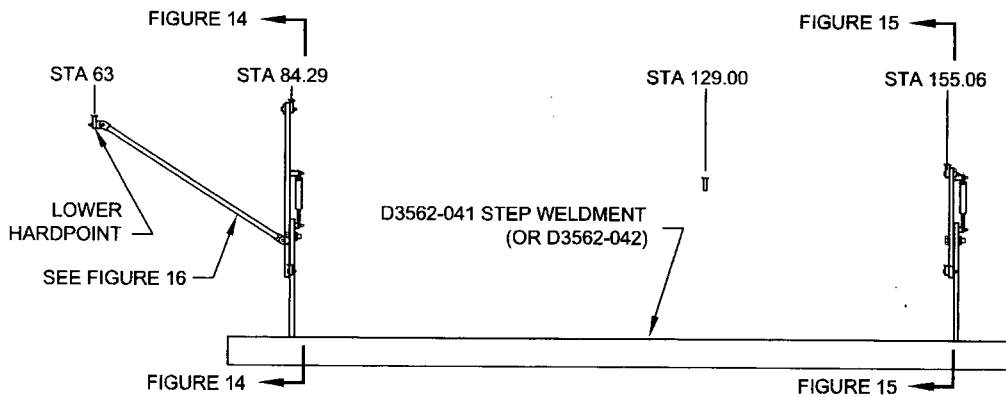
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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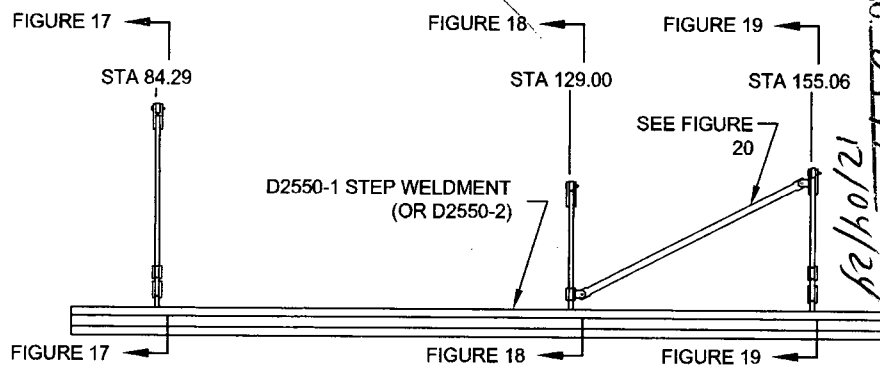
D412-630-023 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)
D412-630-024 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)



D412-630-033 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)
D412-630-034 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)



D412-630-111 HELI-ACCESS-STEP™ LH, HEAVY DUTY FIXED (SHOWN)
D412-630-112 HELI-ACCESS-STEP™ RH, HEAVY DUTY FIXED (OPPOSITE)



SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 83798
 12/04/24
 MCS

FIGURE 3 – D412-630 Heli-Access-Step™ Installations

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 OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: **M**
 Date: 08.12.12

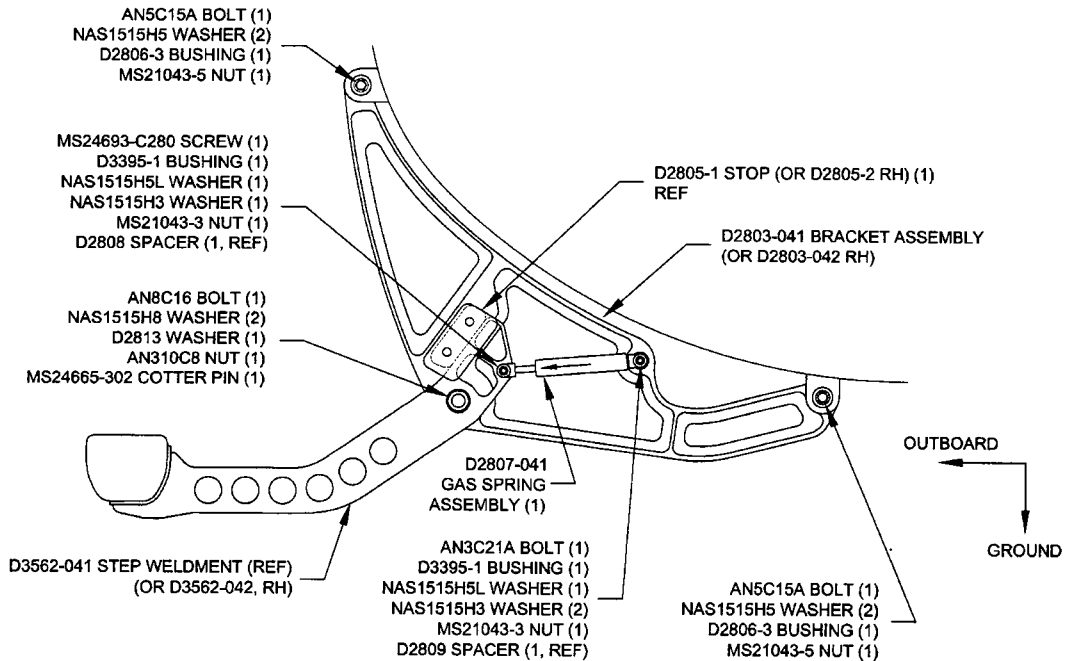
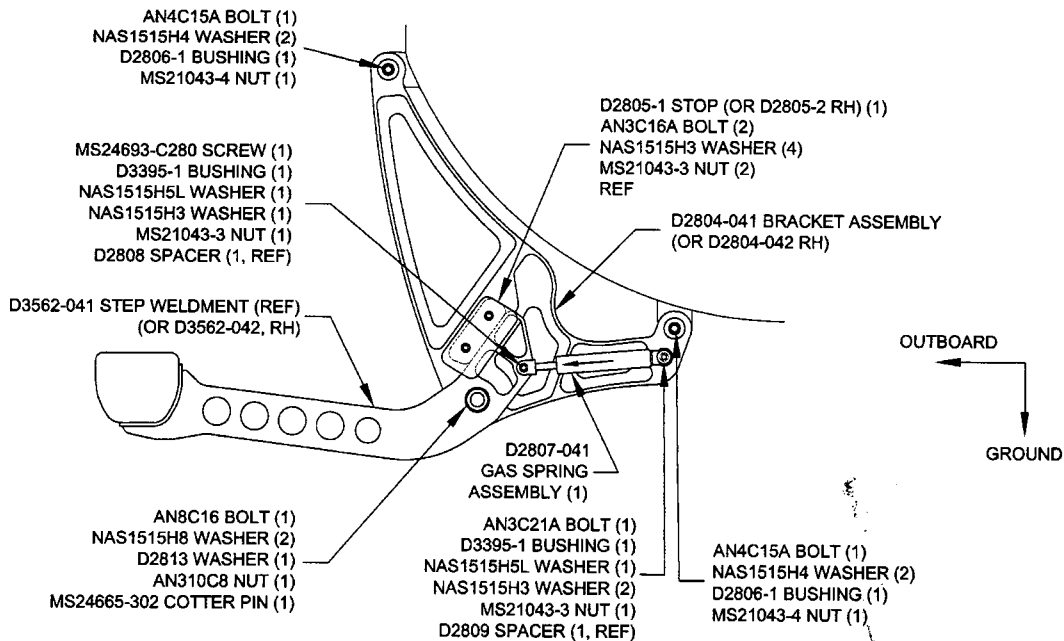
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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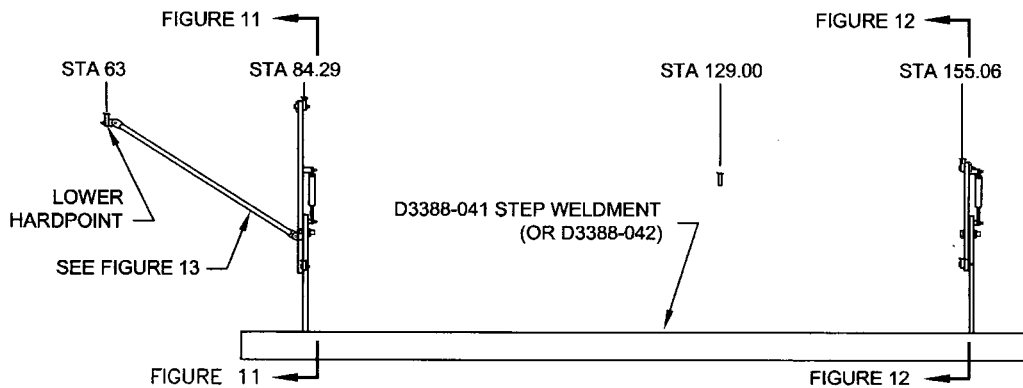
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D412-630-033/-034 Heli-Access-Step™ Installation**FIGURE 25-13: STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)****FIGURE 25-14: STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)**

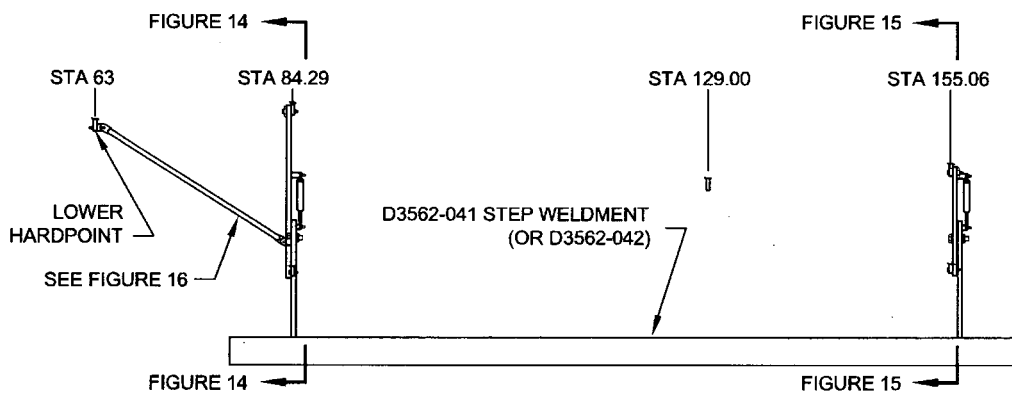
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D412-630-023 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)
D412-630-024 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)



REFERENCE ONLY

D412-630-033 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)
D412-630-034 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)



D412-630-111 HELI-ACCESS-STEP™ LH, HEAVY DUTY FIXED (SHOWN)
D412-630-112 HELI-ACCESS-STEP™ RH, HEAVY DUTY FIXED (OPPOSITE)

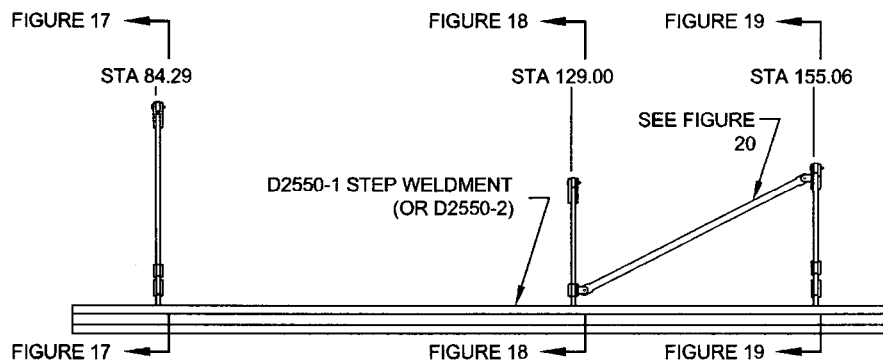


FIGURE 3 – D412-630 Heli-Access-Step™ Installations

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Revision: **M**
Date: 08.12.12

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
		2	2	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4G15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		6	6	NAS1515H3	WASHER
7	7			NAS1515H4	WASHER
7	7			NAS1515H5	WASHER
		4	4	NAS1515H5L	WASHER
		4	4	NAS1515H8	WASHER
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C565)

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